

slip order 5/7

Work Order ID 103909

103909

Page 1

July-04-13 9:44:15 AM

Item ID: 647.1701 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skid Deflector Assembly
 Start Date: 7/04/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/05/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: U Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1700	N/C								

110 Pick Kit 0.00
 110
 Packaging Memo 0.00
 Packaging

① 13.07.05

120 0.00
 120
 Small Fab Memo 0.00
 Small Fab

① 13.07.05

1- Assemble item 4,6,7 and 8 as per dwg.
 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note 6. Use clecos.
 3- Disassemble parts
 3- Deburr
 - touch up holes with alodine
 - touch up holes with primer PR-148
 Batch # 13.07.05
 Permanent Change

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DA 05 9-8-13 07-05
140 *140* Outsource4 Outsource process Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O: ANODIZE AS PER DWG SEE NOTE 3 SHIP TO VENDOR: 647.1710 647.1711 647.1712 647.1713	0.00 0.00							
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00							

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160	QC	0.00							
Quality Control	Memo								
170		0.00							
170	Memo	0.00							
SprayPaint	PRIME AS PER DWG (SEE NOTE 3 ON ECN)								
Spray Painting	PR-148 PRIMER BATCH: _____								
180	QC14- Inspect Spray Paint	0.00							
180	Memo	0.00							
QC									
Quality Control									

N/A 1307.05

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 Required Date: 7/05/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Small Fab Small Fab	Memo ASSEMBLE AS PER DWG	0.00 0.00				①	②	13 07 05	
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAG 05 9-83 13 07 05
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***	0.00 0.00				①	②	13 07 04	

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

13/7/5 [Signature]
 ME
 13-7-5

Picklist Print

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Page 1

Work Order ID: 103909
 Parent Item: 647.1701
 Parent Item Name: Skid Deflector Assembly

Start Date: 7/04/13
 Start Qty: 1.00
 Required Date: 7/05/13
 Required Qty: 1.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

647.1710 Plate		Manufactured	No				Each	24.0000		1			
-------------------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

Location	Loc Qty	Loc Code
MF	12	
92004	2	
92511	2	
93277	8	
ST538	12	
91798	12	

1307.05

647.1711 Plate		Manufactured	No				Each	24.0000		1			
-------------------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

Location	Loc Qty	Loc Code
st543	24	
91799	12	
93413	12	

1307.05

647.1712 Gusset		Manufactured	No				Each	25.0000		1			
--------------------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

Location	Loc Qty	Loc Code
ST438	10	
91800	6	
98683	4	
ST522	15	
93308	10	
93801	5	

1307.05

Picklist Print

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Work Order ID: 103909
Parent Item: 647.1701
Parent Item Name: Skid Deflector Assembly

Start Date: 7/04/13
Start Qty: 1.00

Required Date: 7/05/13
Required Qty: 1.00

647.1713 Manufactured No
Spacer

Each 44.0000 1

Location	Loc Qty	Loc Code
ST139B	24	
91801	10	
92561	2	
93408	12	
st543	20	
99057	20	

13 07.05

CR3213-4-4 Purchased No
Rivet

Each 1,070.0000 22

Location	Loc Qty	Loc Code
ST329	1070	
123301	354	
123785	716	

13 07.05
M 115742 x 16

NAS1149F0332P Purchased No
Washer

Each 10,594.000 2

Location	Loc Qty	Loc Code
GA	182	
122063	182	
ST294	158	
122063	158	
ST295	3	
123352	3	
st510	5251	
123900	5251	
ST510a	5000	
125646	5000	

13 07.05

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Shop Packet Print

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Picklist Print

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Work Order ID: 103909

Parent Item: 647.1701

Parent Item Name: Skid Deflector Assembly

Start Date: 7/04/13

Required Date: 7/05/13

Start Qty: 1.00

Required Qty: 1.00

MS21042-3 MS21042L3 Purchased No

Each 721.0000

1

Nut

Location

Loc Qty

Loc Code

ST314

721

123352

221

123525

500

MS27039-1-14

Purchased

No

Each

1,145.0000

1

Screw

Location

Loc Qty

Loc Code

GA

100

120449

100

ST305

45

112312

17

120177

28

ST506

1000

124326

1000

13 07.05

13 07.05

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Shop Packet Print

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APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03921

SHEET 1 OF 1

DWG NO. 647.1700

REV: N/C

PREPARED BY:

J. BECKER

DATE: 06/07/13

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: SKID DEFLECTOR ASSY

APPROVED BY:

ENGR

T. Bran

MFG

Darrell Barber

QC

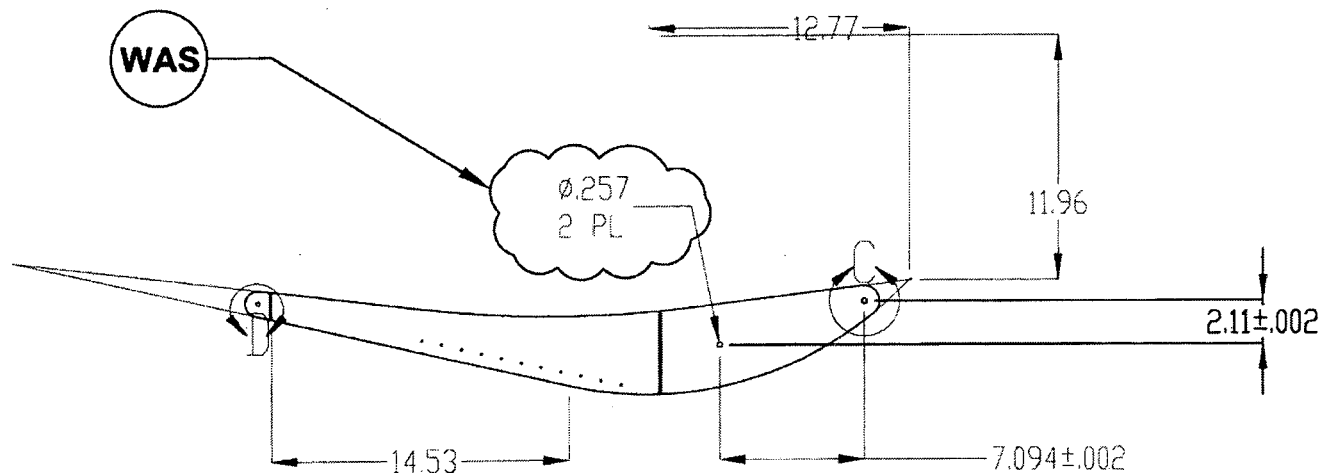
[Signature]

EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: INCREASED DIAMETER OF HOLE. INCORPORATED ECN 03937.



SHEET 3, ZONE D4:

w/0103909

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

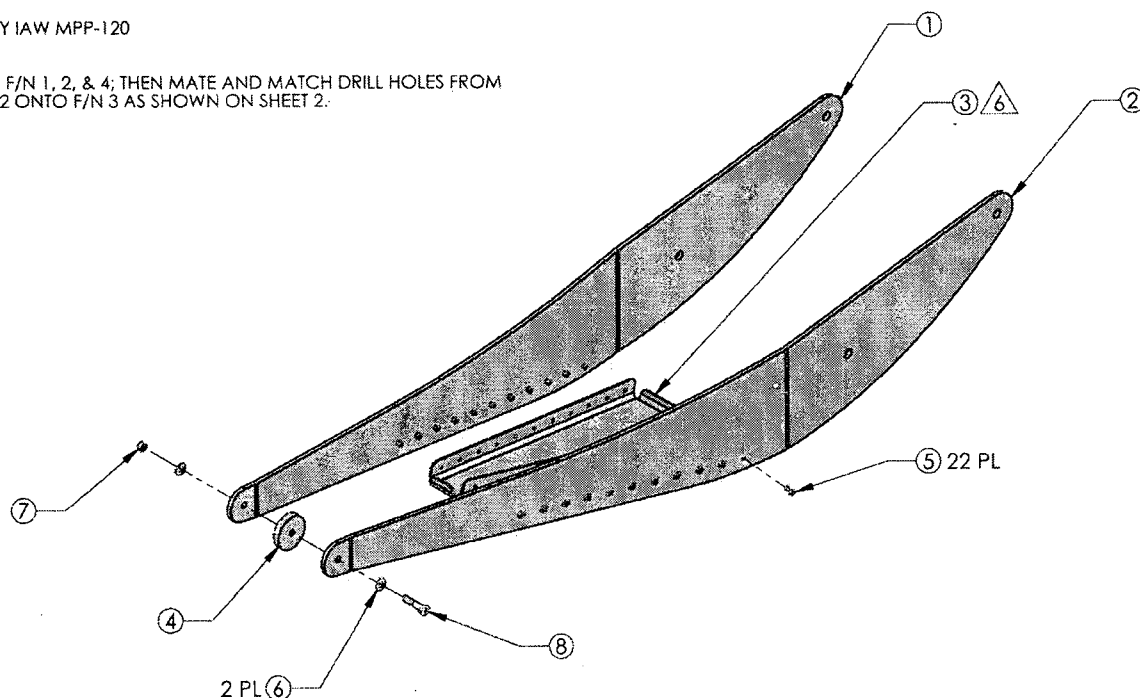
DER REVIEW REQUIRED
☐ YES ☒ NO

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REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROJECT REVISION #22		HAC
HAC	INITIAL RELEASE	08/05/09	P. BRAVO
A	INCORPORATED ECR: 07937 & 07941	05/07/13	P. BRAVO

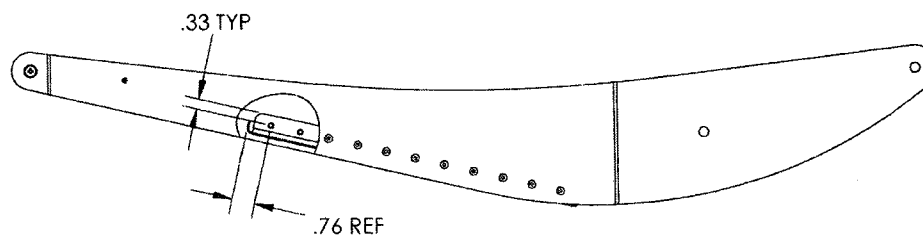
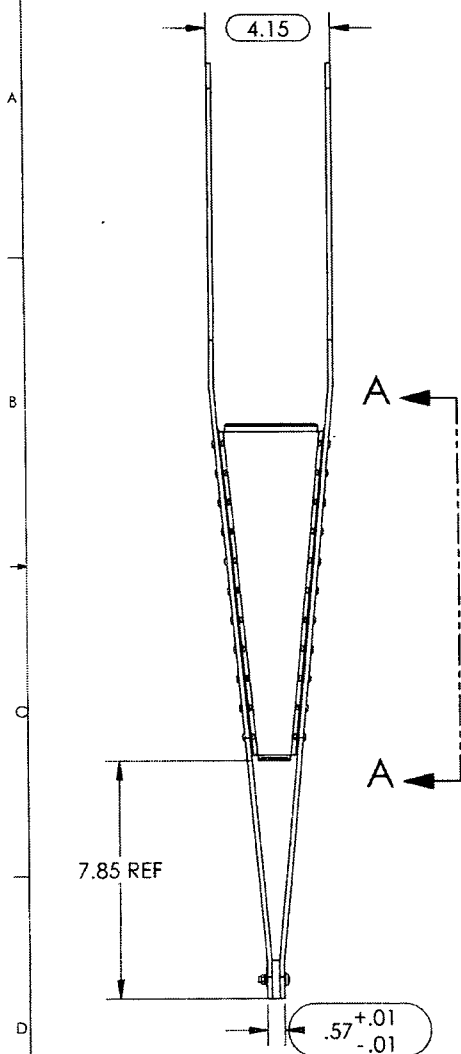
NOTES:

- 1 MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-250/12
- 2 MATERIAL: 6061-T6 ALUMINUM BAR IAW AMS-QQ-A-250/11
- 3 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK; PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER, COLOR BLUE; PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 4 DEBURR AND BREAK ALL SHARP EDGES
- 5 IDENTIFY IAW MPP-120
- 6 CLAMP F/N 1, 2, & 4; THEN MATE AND MATCH DRILL HOLES FROM F/N 1 & 2 ONTO F/N 3 AS SHOWN ON SHEET 2.



QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
1	8	601.1622	SCREW	MS22939-1-14	
1	7	601.2943	LOCKNUT	MS21042-3	
2	6	601.1607	WASHER	MS1149P0332P	
22	5	601.1915	RIVET	CR3213-4-4	
1	4	647.1713	SPACER	△	△
1	3	647.1712	GUSSET	△	△
1	2	647.1711	PLATE	△	△
1	1	647.1710	PLATE	△	△
1		647.1701	SKID DEFLECTOR ASSY		
1	1701	FIND #	PART #	DESCRIPTION	MAT'L SPEC.
PARTS LIST					
NEXT ASSY IS			APICAL INDUSTRIES		
647.1300			2608 TEMPLE HEIGHTS DR.		
			OCEANSIDE, CA. 92056-3512 (760)724-5300		
			SKID DEFLECTOR ASSY		
			UNLESS OTHERWISE SPECIFIED		
			DIMENSIONS ARE IN INCHES		
			TOLERANCES ARE		
			3 PLACES DECIMALS ±.01		
			2 PLACES DECIMALS ±.005		
			ANGLES ± .5°		
			SCALE	NONE	
			SHEET	1 OF 5	

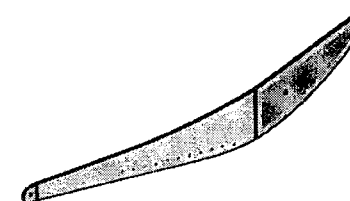
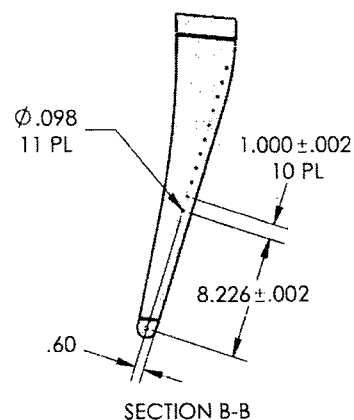
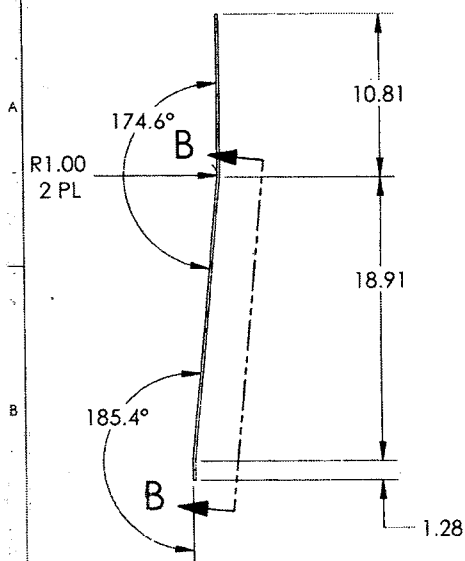
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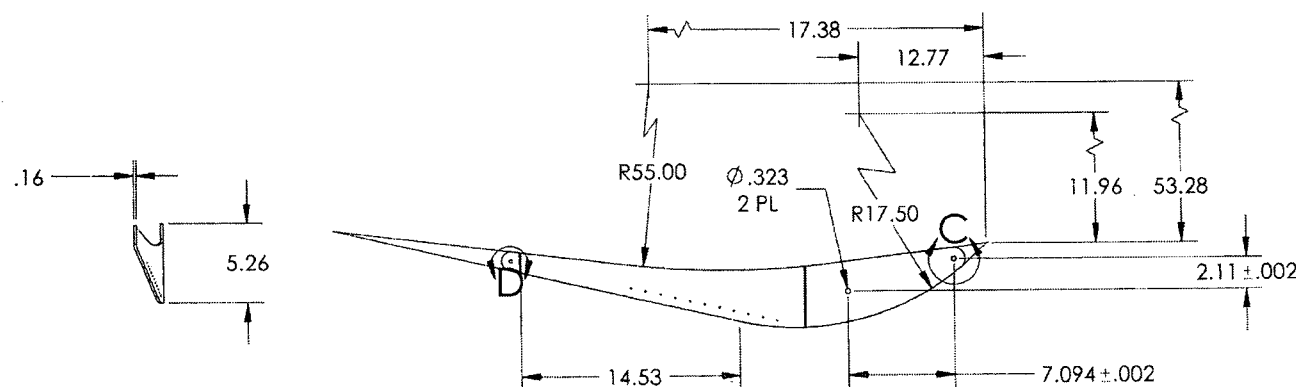
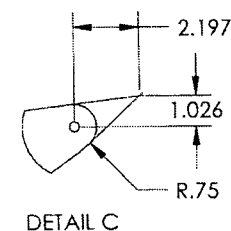
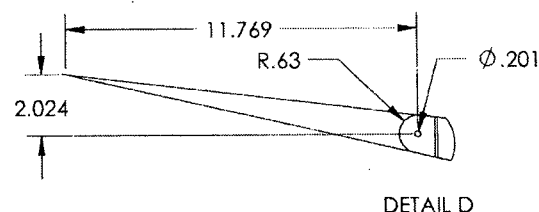
SECTION A-A

ORIGINAL DATE 3/10/2011		APICAL INDUSTRIES	
DRAWN BY J. GARDNER		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAYO		SKID DEFLECTOR ASSY	
CONTRACT NO.		REV.	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET 2 OF 5	

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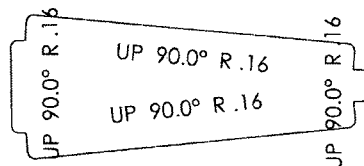
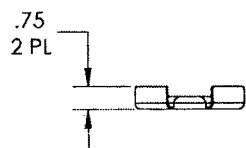
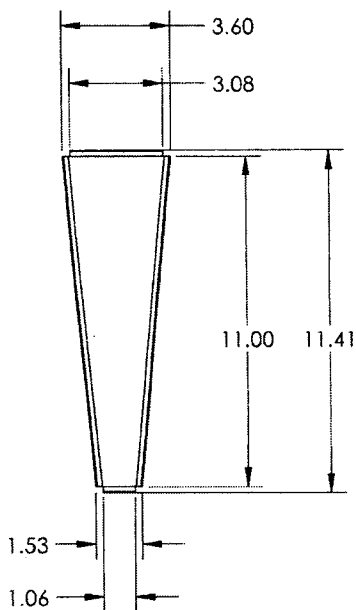


647.1711 SHOWN
647.1710 OPPOSITE

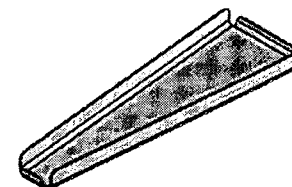
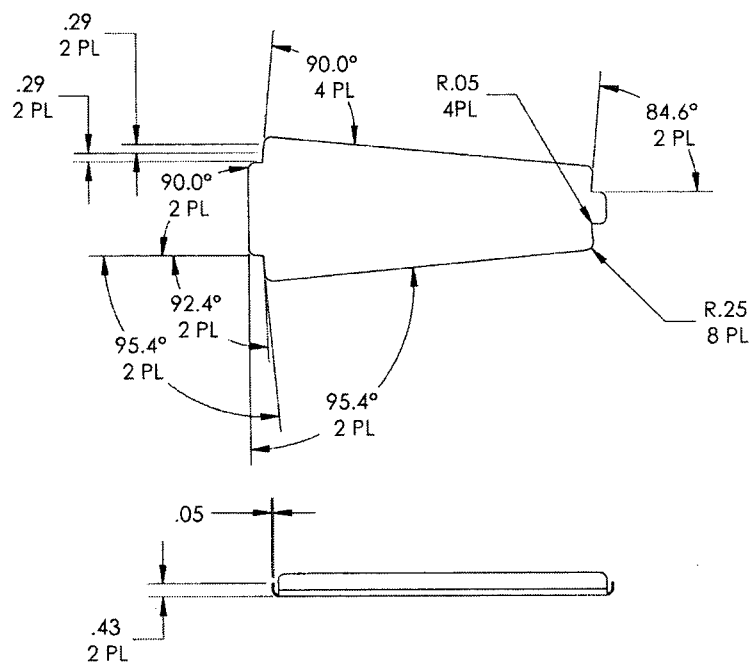


ORIGINAL DATE (M/D/YR)		APICAL INDUSTRIES	
DESIGNED BY		2608 TEMPLE HEIGHTS DR.	
CHECKED BY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL		SKID DEFLECTOR ASSY	
CONTRACT NO.		647.1700	
LARGEST DIMENSION SPECIFIED		SCALE: NONE	SHEET 3 OF 5
DIMENSIONS ARE IN INCHES			
TOLERANCES ARE			
2 PLACE DECIMALS ±.01			
3 PLACE DECIMALS ±.005			
4 PLACE DECIMALS ±.0005			

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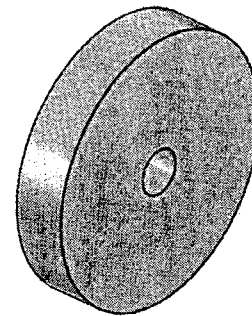
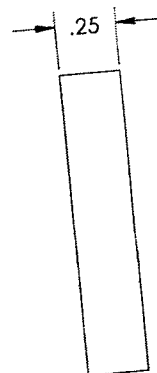
FLAT PATTERN



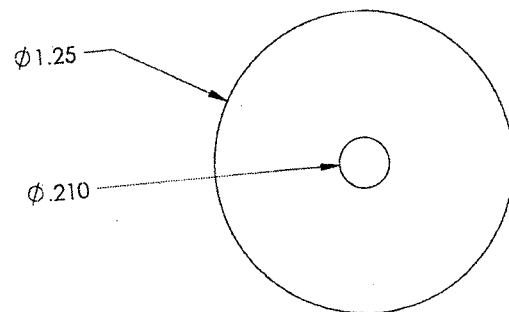
647.1712

ORIGINAL DATE: 05-03-09	APICAL INDUSTRIES		
JMO DATE: 05-23-09	2608 TEMPLE HEIGHTS DR.		
DRAWN BY: J. GARDNER	OCEANSIDE, CA. 92056-3512 (760)724-5300		
CHECKED BY: J. GARDNER	SKID DEFLECTOR ASSY		
DRAWING APPROVAL: F. BAYO	REV: A		
CONTRACT NO:	SHEET 4 OF 5		
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. DECIMALS ARE TO 3 PLACES. DECIMALS TO 3 PLACES. DECIMALS TO 3 PLACES. DECIMALS TO 3 PLACES.			
APICAL INDUSTRIES			
2608 TEMPLE HEIGHTS DR.			
OCEANSIDE, CA. 92056-3512 (760)724-5300			
SKID DEFLECTOR ASSY			
REV: A			
SHEET 4 OF 5			

2
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647.1713



ORIGINAL DATE		DESIGN	
INDEXED BY	PROJECT	APICAL INDUSTRIES	
DRAWN BY	DATE	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY	DATE	SKID DEFLECTOR ASSY	
DRAWING APPROVAL		REV. A	
DATE		SHEET 5 OF 5	
CUTTING NO.		SCALE NONE	
TITLE, QUANTITY, SPECIES		ENG. NO. 647.1700	
DIMENSIONS ARE IN INCHES		DATE 07/26/86	
TOLERANCES ARE:		SCALE NONE	
FRACTIONS DECIMALS 2:1		SCALE NONE	
2 PLACE DECIMALS 1:1		SCALE NONE	
ANGLES 1:1		SCALE NONE	

